

duplicate

Dart Aerospace Ltd.

Date: Monday, 14/04/2008 9:06:22 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: R/H LOW PROFILE BASKET BASE ASS'Y
Job Number	: 38460		
Estimate Number	: 13171		
P.O. Number	:	Part Number	: D3712042
This Issue	: 14/04/2008 S.O. No. :	Drawing Number	: D3712 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 08/04/2008 Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 38217	Material	:
Written By	:	Due Date	: 25/04/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JLD 08.4.14</u>		
Comment	: Est Rev:A new issue 08-01-30 DD verified by:EC Est Rev:B chg to revB ecn 1145 08-03-19 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 44.7920 f(s)/Unit Total : 44.7920 f(s)
304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3726-1	<u>M107514</u>
2	D3727-1	<u>M107514</u>
2	D3734-1	<u>M107514</u>
6	D3735-1	<u>M107514</u>
3	D3739-1	<u>M107514</u>
3	D3740-1	<u>M107514</u>



2- deburr

See 08/04/13

2.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spacer Bushing
batch 336479 ✓

Pl 08.04.22

3.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Mounting Bracket
batch 037243 ✓

Pl 08.04.22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/04/2008 9:06:22 AM
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Job Number: 38460

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch

*337127 → * 1 B38169 → 1 ✓ Pl 08.04.22*

5.0

D37481

HINGE HALF



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

HINGE HALF

batch

*337305 → * 1 B38225 → 2 ✓ Pl 08.04.22*

6.0

D31661

Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Batch:

337572 ✓ Pl 08.04.14

7.0

D37591

BUSHING



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

BUSHING

batch

338236 → 7 B38416 → 14 ✓ Pl 08.04.22

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- take D3166-1 and trim as per dwg D3746 to make D3746-1, D3746-3, D3746-5 and D3746-7

2- take D3746-3, D3746-5, D3746-7 and drill holes as per dwg D3746 using drill jig DT8995 and DT8996

3- drill holes in both D3727-1 as per dwg D3727

4- drill holes in D3735-3 as per dwg D3735

5- deburr

6- assemble as per dwg D3712 and weld as per QSI004

Pl 08.04.22 Pl 08.04.22

Dart Aerospace Ltd

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Job Number: 38460

Part Number: D3712042

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.9000 sf(s)/Unit Total: 39.9000 sf(s)

Expanded Metal Flat Stainless Steel

Pick:

Qty Part Number Description Batch
38sq.ft M304EX0.75-16F Expanded Metal

M107511V

SAT 08/04/22

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- cut mesh to fit inside basket base and sides as per dwg D3744 and D3745

SAT 08/04/22

(P)

2- weld mesh as per dwg D3712

Pl 08-04-23

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAT 08/04/24

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SAT 08/04/24

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 08-04-24

(X)

14.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M- 08/04/24

(1X)

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

338460
D3712042
24/04/2008

S.115 15.20
#1 402.9 F
#2 --- F
#3 30mins F
#4 --- F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 38460

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bumper 21139

AS 08/04/28 (X1)

17.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt M14820

AS 08/04/28 (X1)

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer M107091

AS 08/04/28 (X1)

19.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer M107715

AS 08/04/28 (X1)

20.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Cherry Rivets M18071

AS 08/04/28 (X1)

21.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Nut M107644

AS 08/04/28 (X1)

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3712

M108/04/28

PTO

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/28

~~21.0 Still missing 2x Blanking plate~~
~~1x B38068~~
~~1x B38775~~

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/04/28	22	Still missing 1 2x Blanking plate 1x B38068 1x B38775	ml 08/04/28	08/04/28	2	U	S 08/04/28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 38460

Part Number: D3712042

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP 38443

8/4/28

SLP

25.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/28

Comment: FINAL INSPECTION/W/O RELEASE

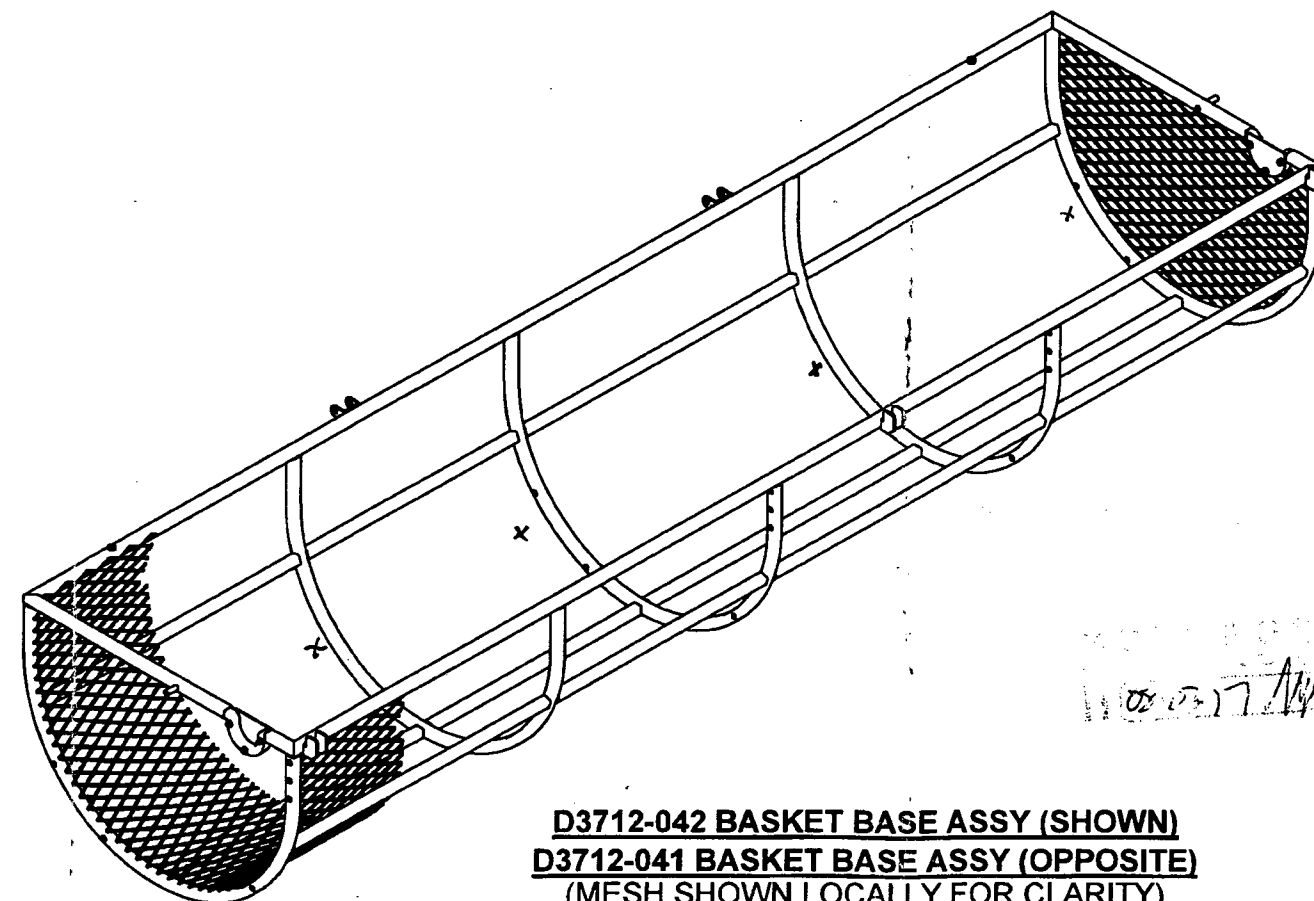
Job Completion



U 08.24.28

8 7 6 5 4 3 2 1

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3712-041	BASKET BASE ASSEMBLY
	X	D3712-042	BASKET BASE ASSEMBLY
2	2	D2327-3	SPACER BUSHING
2	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
2	2	D3725-1	HOOP
2	2	D3726-1	RIB
2	2	D3727-1	RIB
2	2	D3734-1	RIB
5	5	D3735-1	RIB
1	1	D3735-3	RIB
3	3	D3739-1	RIB
3	3	D3740-1	RIB
1	1	D3744-1	MESH
1	1	D3746-1	RIB
1	1	D3746-3	RIB
2	2	D3746-5	RIB
1	1	D3746-7	RIB
3	3	D3748-1	HINGE HALF
2	2	D3757-1	BLANKING PLATE
21	21	D3759-1	BUSHING
6	6	AN3-11A	BOLT
2	2	AN960JD8	WASHER
12	12	AN960JD10	WASHER
2	2	MS20600AD4W3	RIVET
6	6	MS21042L3	NUT



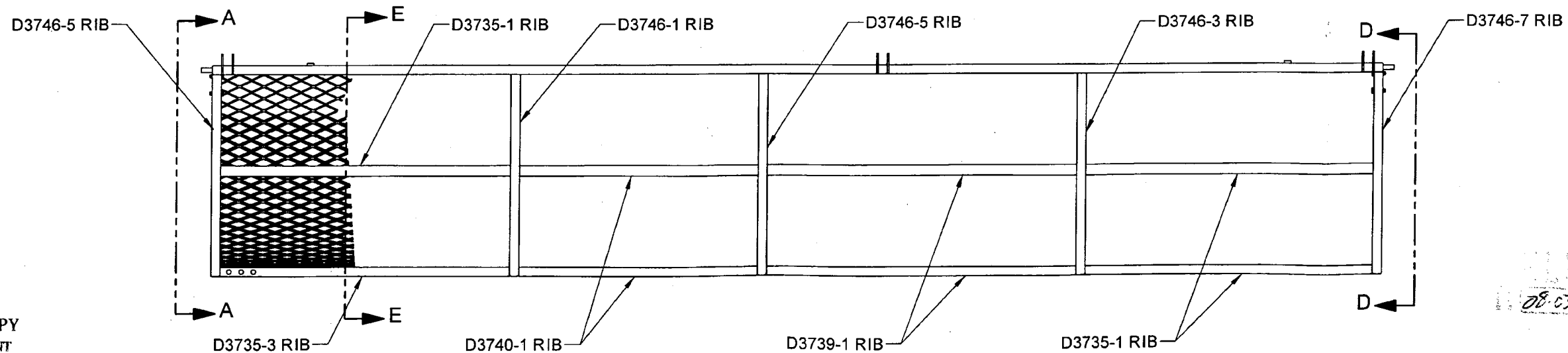
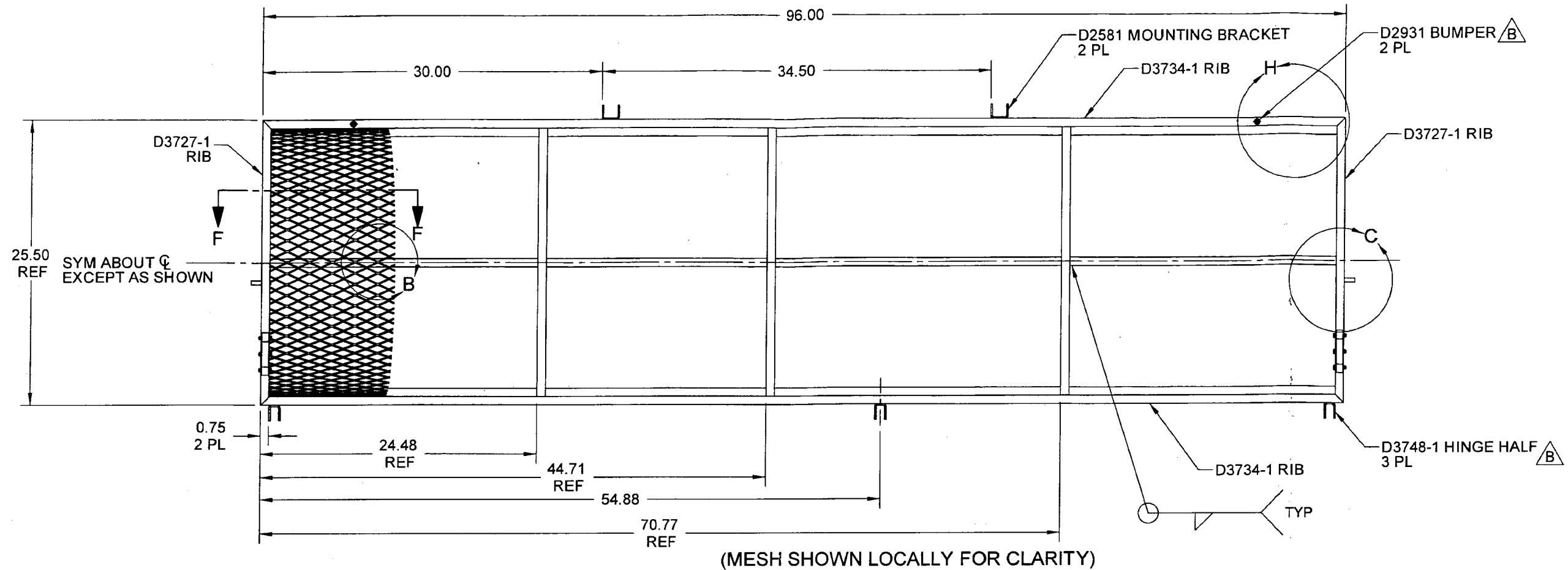
D3712-042 BASKET BASE ASSY (SHOWN)
D3712-041 BASKET BASE ASSY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

B	ADDED-041 ASSEMBLY. WEIGHT WAS 41.50 lbs. ADDED D2931 BUMPER & HARDWARE & D3759-1 BUSHINGS. SHEET 2 ZONE C2 QTY FOR D3748-1 WAS 2. SHEET 4 ADDED DETAIL H. SHEET 3 ZONE C3 & SHEET 4 ZONE C4. ADDED MESH TRIMMING INSTRUCTIONS. SHEET 4 ZONE D2 AN3-11A BOLT WAS AN3-10A P/L UPDATED ACCORDINGLY.	AJS	08.02.22
A	NEW ISSUE	AJS	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	DS	D3712	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET BASE ASSY	NTS
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NOTES:
1) MATERIAL: NONE
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) WELDING: PER DART QSI 004
9) MASK ALL HOLES PRIOR TO POWDER COATING.

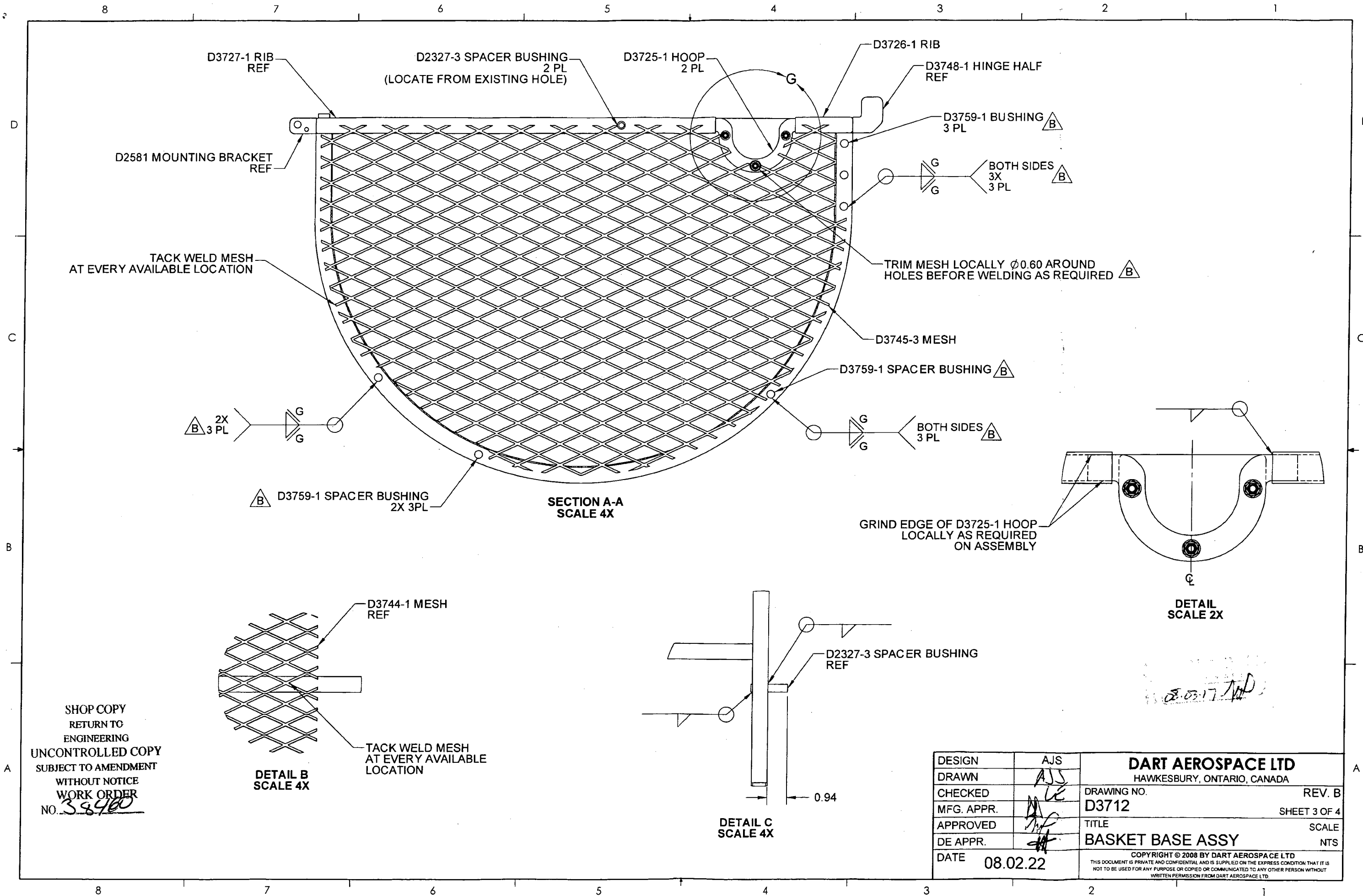
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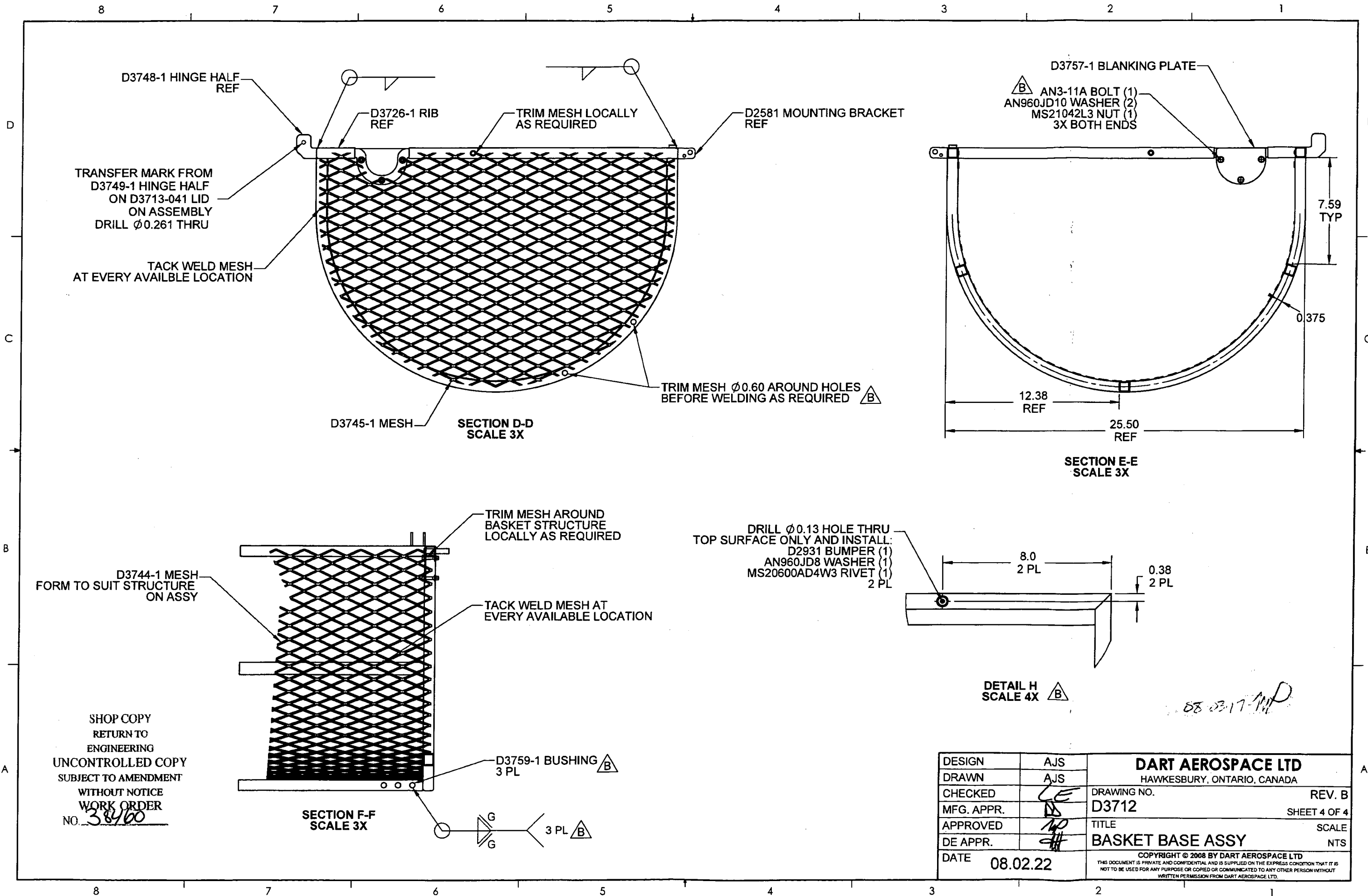
- 9 D3712-041 BASKET BASE ASSY (OPP)
9 D3712-042 BASKET BASE ASSY (SHOWN)

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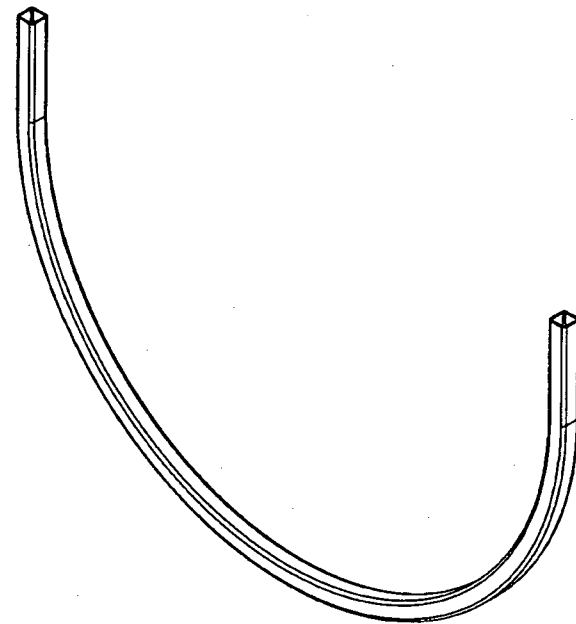
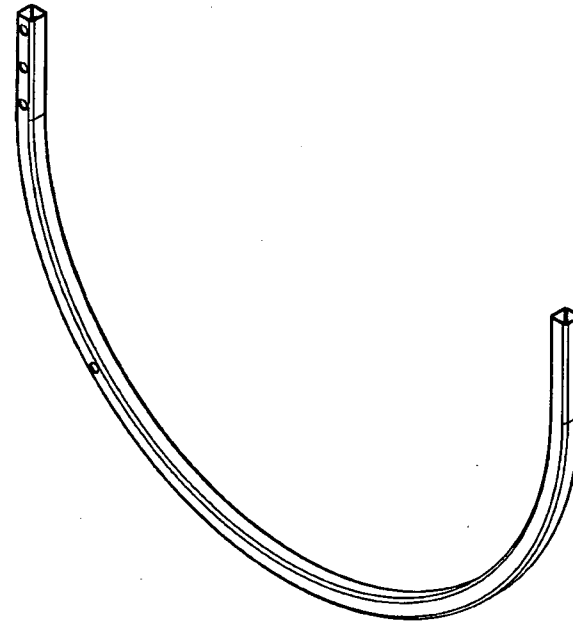
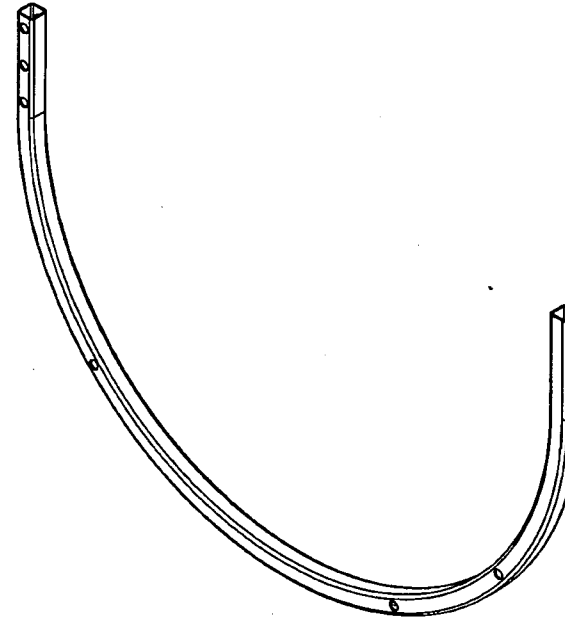
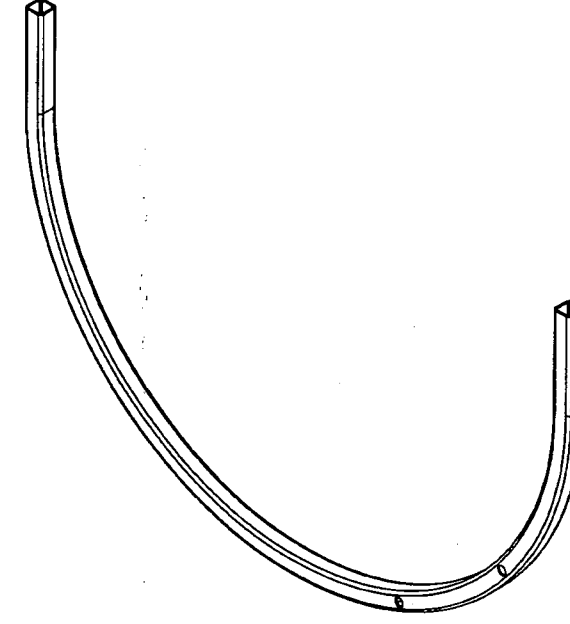
C

B

B

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A

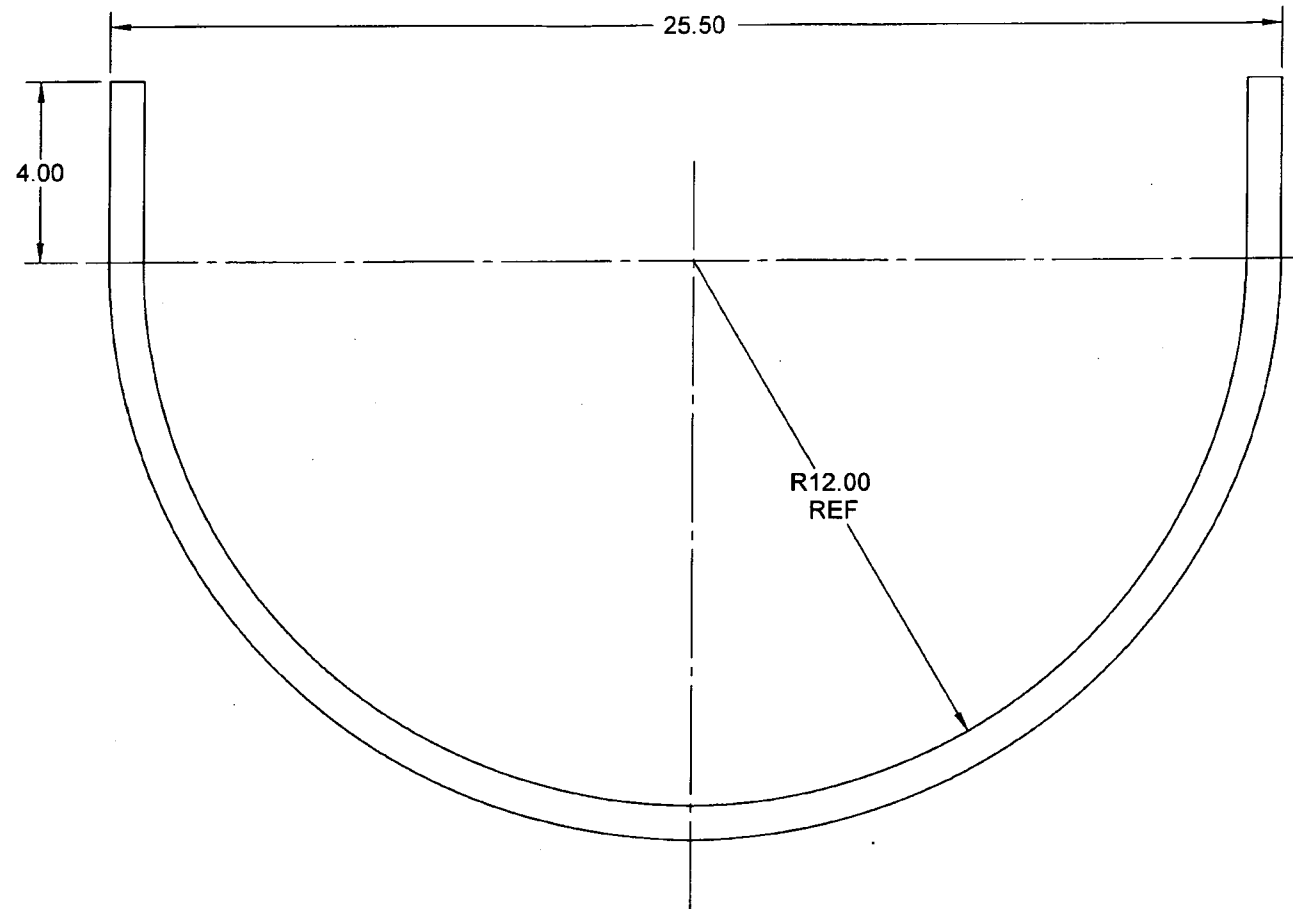
**D3746-1 RIB****D3746-3 RIB****D3746-5 RIB****D3746-7 RIB**

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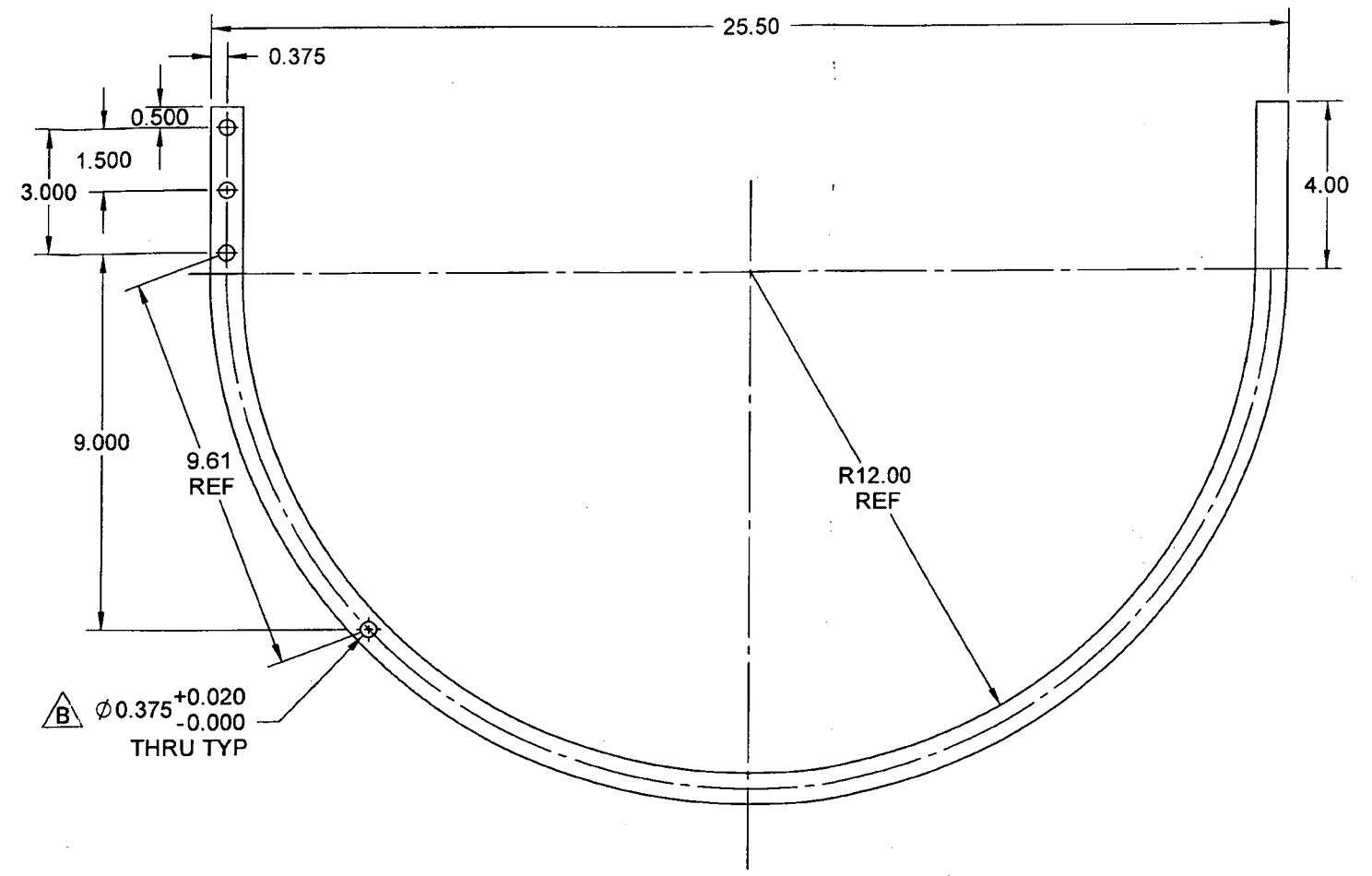
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.25 lbs
- 8) M/F D3166-1 BASKET HOOP

B	SHEET 2 ZONE C4, B4 & SHEET 3 ZONE C7. HOLES WERE Ø0.257. SHEET 3 ZONE B2 & B5 HOLES WERE Ø0.191. SHEET 3 ZONE 7B HOLE QTY WAS 4PL.	AJS	08.03.03
A	INITIAL RELEASE	AJS	08.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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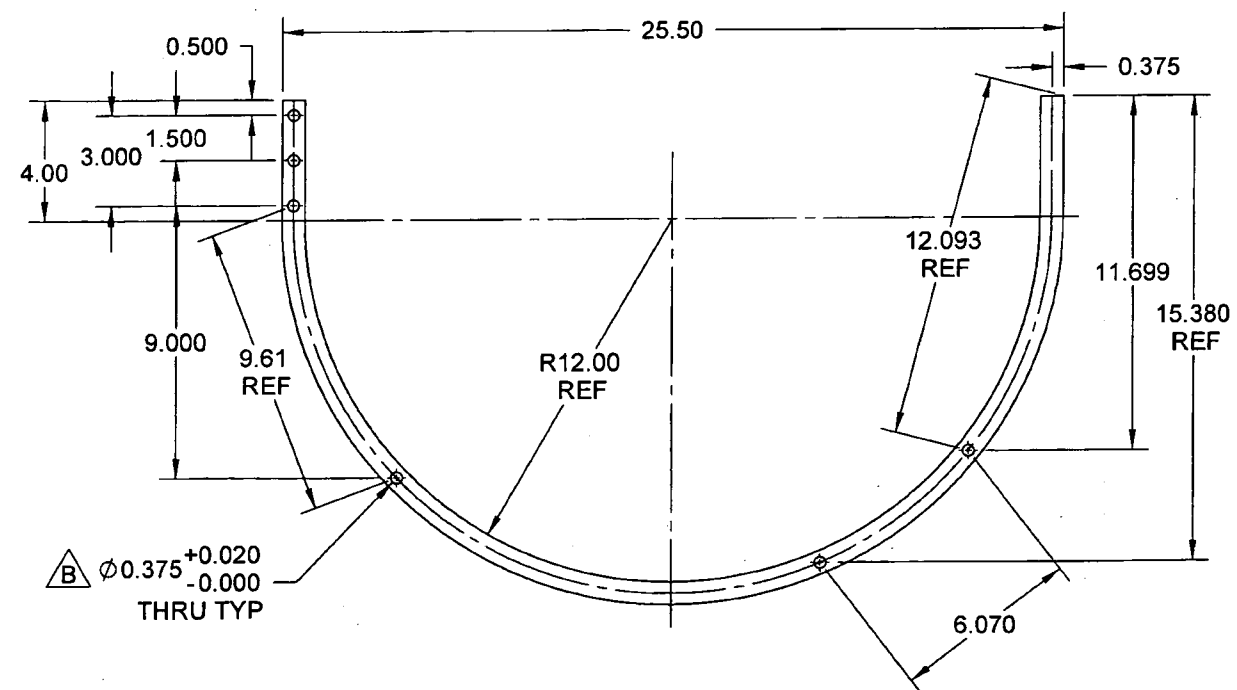


D3746-3 RIB

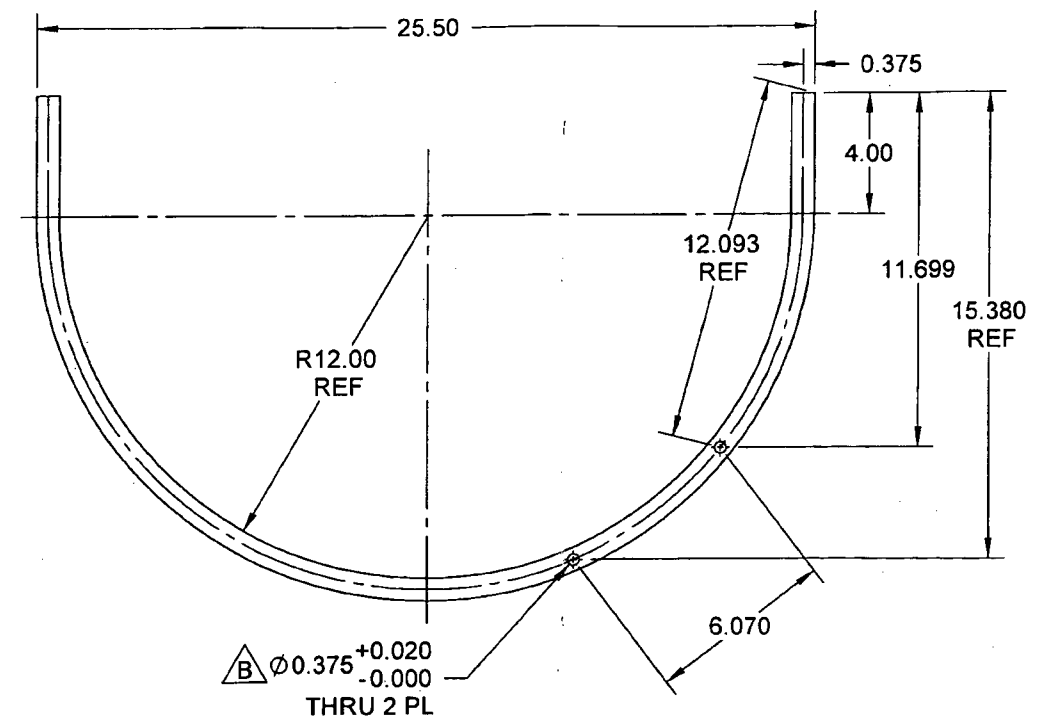
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08-03-17 *MP*



D3746-5 RIB



D3746-7 RIB

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